	er ID 58844 • 19, 2010 1:38:33 PM	L								Page 1
Item ID: Revision ID:	D3779-041		Accept					Setup Sta	rt	
Item Name:	Handle Assembly (Exterior)							Sto	p	
Start Date:	5/19/2010 Start Qty: 1.0	o	,	Cust Item I	D.				1 18811181	#1946 (16 (16) (24)
Required Date:				Customer:	υ.					
Reference:		*		·						•
Approvals:	Process Plan:	Date:/05-19	Tooling:	Da	nte:	_	1	Run Sta		
	QC:	Date:	SPC (Y/N):	Da	nte:			Sto	P	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp.
Draw Nbr	Revision Nbr	, , , , , , , , , , , , , , , , , , , ,				,,,,,,				
D3779	Rev A									
	FLOW WATER JET		0.00	·			HZ	10-5-3		
Waterjet FLOW CNC Waterjet	D-1	per Dwg D3779 Dwg Rev:	0.00 Prog Rev:	A 🗆 2-					Ç	\mathfrak{D}
1 10 	QC2- Inspect parts o	ff machine FAI/FAIB	0.00							
QC Quality Control	Memo		0.00				1&	(0-5-	7	
120	QC8- Inspect parts -	second check	0.00	wloslaz						
QC Quality Control	Memo		0.00	10105127			_€2			· ———

Dart Aer	ospace	Ltd
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W/O:			WC	RK ORDER CHANC	GES					
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes I	No DQA	\:	Date:	
		esolution:								
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC			tion B	0: 0	Verific	ation	Approval	Approvai
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
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Work Order ID 58844

Wednesday, May 19, 2010 1:38:33 PM



Page 2

Item ID:

D3779-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Handle Assembly (Exterior)

Start Date:

5/19/2010

Start Qty: 1.00

Required Date: 5/26/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan:

Date:_____

Date:_

Tooling:

Date:

Draw

Number

Date:

Draw

Rev.

Plan

Code

Start Run



Stop

Sequence ID/ **Work Center ID**

130

Small Fab

Small Fab

Small Fab

Operation

Description

Memo

Run Hours 0.00

SPC (Y/N):

Set Up/

0.00

1- counter sink holes as per dwg D3779 2- deburr

Accept Qty.

Reject Qty

Reject Insp. Number

Stamp

140

QC Quality Control QC5- Inspect part completeness to step on W/O

0.00

0.00

2 10/06/10

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

Memo

0.00

D bl/0-6-12

Dart A	Aerospace	Ltd
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W/O:			WC	RK ORDER CHANGES		. '		
DATE	STEP	PROC	EDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
		•						
Part No	: <u> </u>	구국~ 6년 PAR #:	_ Fault Cate	gory: Small feb N	ICR: (Yes) N	lo DQA:	Date: <u>/ <</u>	0000
	R	esolution: Swap	_ Disposition		A: N/C Clo	~ 100	Date:10	106/24
NCR: 59	8844	W	ORK ORDE	R NON-CONFORMANO	CE (NCR)	<i>O</i> _		
DATE	0750	Description of NC		Corrective Action Section B		Verification	Annessal	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
		I part is scrap countersink on the surong side K.C Henon Henor.	1	Singa destroy	EB 10/06/10		1	- w. 1
05/3	130	counterink on		Surp + destroy	10/06/10			
`		the riving side	psicus	100 (01)	1 7 7 7	1 0	600	
		R.C Henon Holmon.	/			whole	Posicie	10.06.10
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Work Order ID 58844

Wednesday, May 19, 2010 1:38:33 PM



Page 3

Item ID:

D3779-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Required Date: 5/26/2010

Handle Assembly (Exterior)

Start Date:

5/19/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID: Customer:

Reference:

An	provals:	
7 7 12	provais.	

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

160

Operation Description

QC3- Inspect Part Finish

Set Up/ **Run Hours**

Draw Number Draw Plan Rev. Code

Reject Accept **Qty**

Reject Number

Insp. Stamp

QC

Memo

0.00

Qty

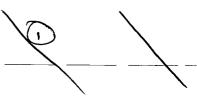
Quality Control



dentify as per dwg & Stock Location 0.00 0.00 Memo







180

Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1- rivet D3203-1 handle to D3779-1 plate as per dwg D3779 per QSI003

W/O:		0.00	W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A :	_ Date: _	_
		esolution:							
NCR:			WORK ORI	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC	1	Corrective Action Section		Verific	ation	Approval	Approval
	-	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector
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Work Order ID 58844

Wednesday, May 19, 2010 1:38:33 PM



Page 4

Item ID:

D3779-041

Accept

Setup Start



Revision ID:

Item Name:

Handle Assembly (Exterior)

Start Date:

5/19/2010

Start Qty: 1.00

Operation

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:_____

Tooling:

Date:_

Run

Start

Stop



QC:

Required Date: 5/26/2010

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ **Work Center ID**

Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours** Draw Number

Plan Draw Rev. Code Accept Reject Qty

Reject Number

Insp. Stamp

QC

Quality Control

Memo

Memo

Qty

200

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

0.00

210

OC

QC21- Final Inspection - Work Order Release

0.00

Memo

10/06/24 X) M(0-6-24)

Quality Control

0.00

	Dart	Aeros	pace	Ltd
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W/O:			WC	ORK ORDER CHANG	ES			1
DATE	STEP	PRO	OCEDURE CHA		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			 					
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes I	No DQA:	Date: _	
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NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)		
DATE	STEP	Description of NC	Initial	Corrective Action Section	on B	Verification	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Date	Section C	Chief Eng	QC Inspector
								-
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Picklist Print

Wednesday, May 19, 2010 1:38:38 PM

Work Order ID: 58844

Parent Item:

D3779-041

Parent Item Name:

Handle Assembly (Exterior)

Comments:

IPP Rev:A 08-06-09 new issue DD verified by:ec

Start Date: 5/19/2010

Required Date: 5/26/2010

Page 1

Start Qty: 1.00

Required Qty: 1.00

II	PP Rev:B 08-07	-21 procedure cl	nange 1	DD verified b	y:EC				- •			
Component Item ID/ Item Name MS20426AD10-8 Rivets	Replacement Item ID	Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID 100	Unit of Measure Each	Qty on Hand 289.0000	Qty per Kit	Qty Issued	Date Issued	Status
				Location ST318		<u>Loc</u>	Oty 289	Loc Code		V		
D3203-1		Manufactured	No		110153	180	239 50 Each	6.0000		B58-	1,5,,,,,	
Handle	# 1 186 1			Location ST240		<u>Loc</u>	<u>Otv</u> 6	Loc Code	111111111111111111111111111111111111111	<u>127 @</u>	115/016	-700
M6061T6S.125		Purchased	No		56366	180	6 sf	177.0500	0.194	75		_
6061-T6 .125 Sheet	1810 IB 110101 11010 1100 1 111	lii ·		Location		<u>Loc</u>		Loc Code			1810-C-3	
	v.				112476 113424 113608	17	77.05 11 6.05 96		 	117476		ව

114352

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DATE	STEP	PRO	CEDURE C	HANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	itegory: _		NC	R: Yes	No DQ	\:	Date: _	
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NCR:		V	VORK OR	DER N	ON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial		ctive Action Action Descript	Section B	Sign &	Verific		Approval	Approval
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DART AEROSPACE LTD	Work Order:	38844
Description: Plate	Part Number:	D3779-1
Inspection Dwg: D3779 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	-194	7			
Ø0.316	+0.006/-0.001	-317	de			
0.40	+/-0.030	,५०१	8		***	
2.300	+/-0.010	205.6	>		40.0	
4.100	+/-0.010	4.102	8			
4.100	+/-0.010	4.102	*			
9.00	+/-0.030	9.007	7			
3.10	+/-0.030	3.100	*			
1.02	+/-0.030	1.017	کار			
6.960	+/-0.010	6.958	is	,		
1.000	+/-0.010	1.001	×			
1.05	+/-0.030	1.050	8			
0.125	+/-0.010	,119	8			
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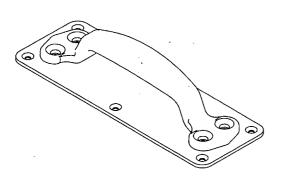
Measured by:	B	Audited by:	Prototype Approval:	N/A
Date:	10-5-27	Date: 10/15/27	Date:	N/A

A 08.10.07 New Issue P/O D3779-041 KJ/DD	Re	v Date	Change	• •	Revised þy∧	Approved
	_ <i>F</i>	08.10.07	New Issue	P/O D3779-041	KJ/DD akl	7

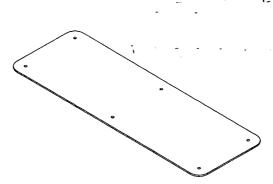
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QTY. -043 PART NUMBER DESCRIPTION D3779-041 HANDLE ASSEMBLY D3779-043 HANDLE ASSEMBLY D3203-1 HANDLE D3779-1 PLATE D3779-5 PLATE MS20426AD10-8 RIVET, CSK

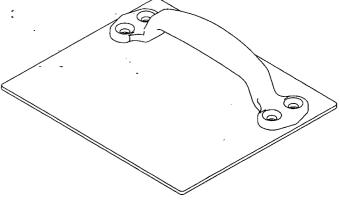
SHOP COPY **RETURN TO** ENGINEERING **UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER







D3779-3 DOUBLER PLATE



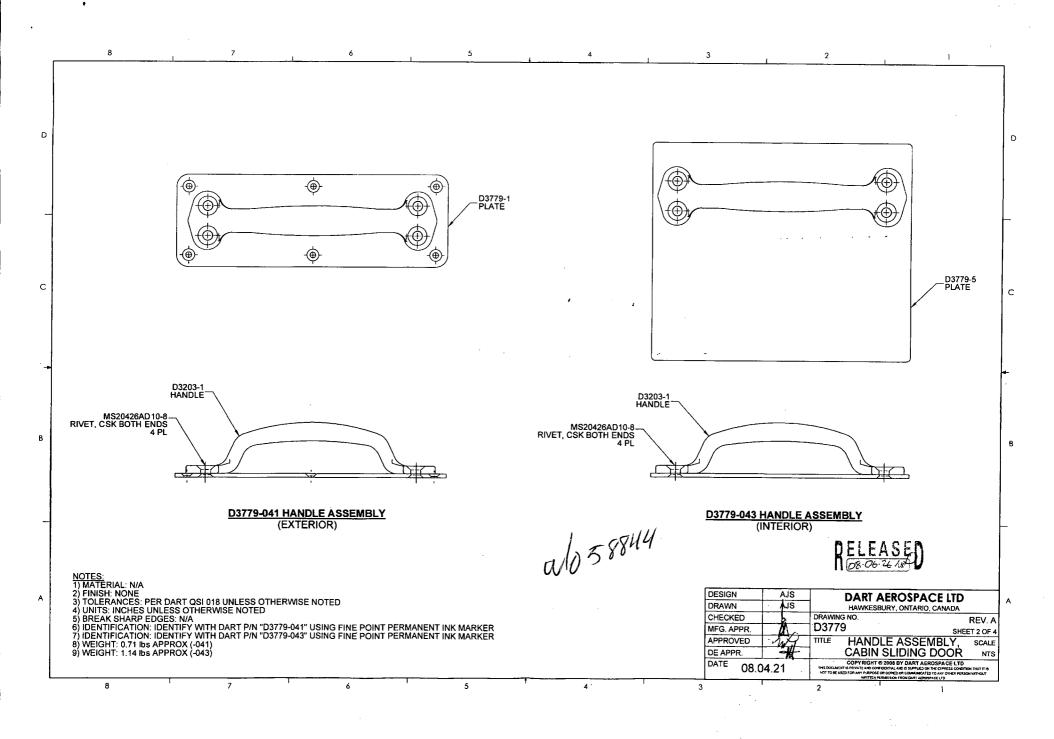
D3779-043 HANDLE ASSEMBLY (INTERIOR)

Α	NEW IS	SSUE		08.04.21						
REV.			DESCRIPTION	DESCRIPTION BY						
DESIG	N	AJS	DART A	DART AEROSPACE LTD						
DRAW	V.	AJS	HAWKESBURY, ONTARIO, CANADA							
CHECK	ED	6.	DRAWING NO.		REV. A					
MFG. A	PPR.	21/0	□ D3779		SHEET 1 OF 4					
APPRO	VED		TITLE HANDLE	SCALE						
DE APP	PR.	V-1/1	CABIN S	LIDING DOO!	R nts					
DATE	08.0	04.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PROVIDE AND COMPRESSION OF A LIFE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ARY PAYFORD OF COPIED OR COMMUNICATED TO ANY TODRE PERSON WITHOUT WRITTEN PERSONS OFFEN MANY ARROPACE LTD WHITTON PERSONS OFFEN MANY ARROPACE LTD							

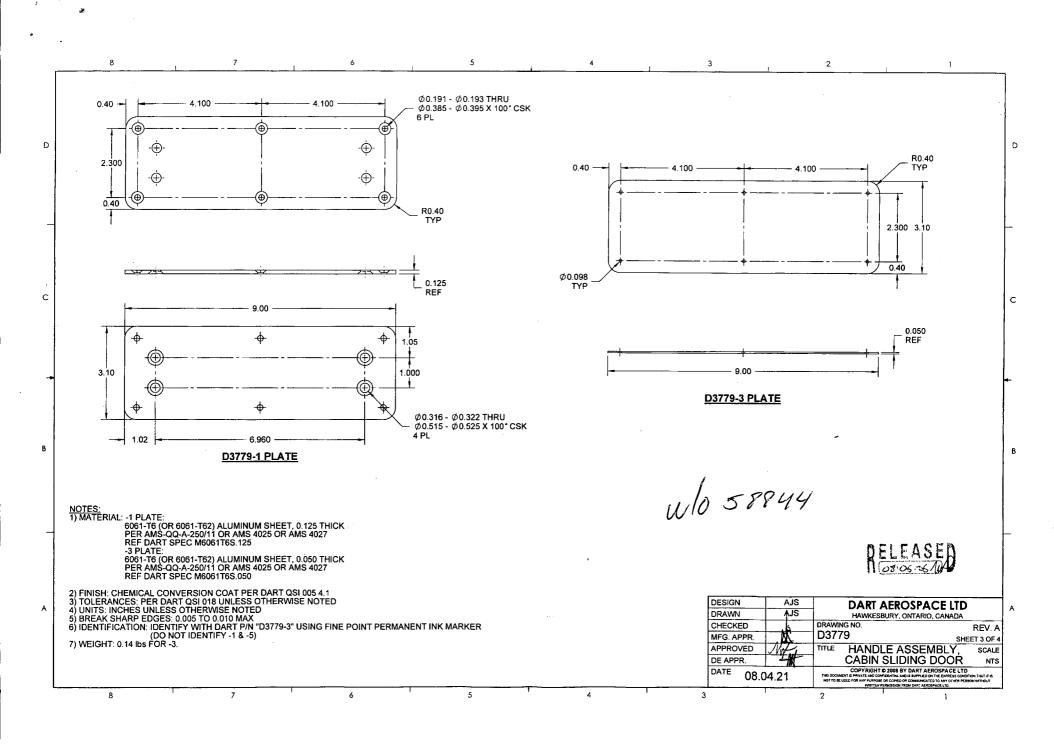
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Part No	•	PAR #:	Fault Cate	gory:	NCI	R: Yes	No DQA		_ Date: _	
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R0.13 TYP 7.31 Ø0.316 - Ø0.322 THRU Ø0.515 - Ø0.525 X 100° CSK 1.000 1.30 0.82 6.960 -**D3779-5 PLATE**

-1-0.125 REF

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NOTES: 1) MATERIAL: -5 PLATE: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF DART SPEC M6061T6S.125

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: SEE SHEET 2 FOR ASSEMBLED WEIGHT

DESIGN	AJS	DART AEROSPACE LTD					
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA					
CHECKED		DRAWING NO. REV.	Α.				
MFG. APPR.	M	D3779 SHEET 4 0	F 4				
APPROVED	1 M	TITLE HANDLE ASSEMBLY, SCA	LE				
DE APPR.	-#-		TS				
DATE 08.0	04.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS COCUMENT & PRIVATE AND COMPOSITION, AND IS SUMPLED ON THE COMPASS COMMITTON THAT IT IS NOT TO BE USED FOR ANY PARFOLD ENCOMED ON COMPANIONATED TO ANY OTHER PERSON WITHOUT WRITTEN PERSONS ON TWO DART ARROSPACE LTD.					

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Dart Aero	space	Ltd
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W/O:		WORK ORDER CHANGES											
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